

Work Order ID 53833

November 20, 2009 8:38:57 AM

Page 1

Item ID: D4011-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp, Long

Start Date: 11/19/09 Start Qty: 20.00

Cust Item ID:

Required Date: 11/24/09 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

101

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per Drwg D4011

Rev B Prog. Rev B

Deburr if necessary

139-11-21

38

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

139-11-21

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 802/11/23

counts
139

38

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D4011-3 ⁷⁰⁴⁰⁷⁻⁵⁵⁹⁻¹¹³ PAR #: _____ Fault Category: Small Pbs / w. Set NCR: Yes No DQA: [Signature] Date: 05.11.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 05.11.27

| NCR: <u>53833</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|----------|---|-----------------------------|---|------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 9/6/23 | * 100 | Qty +1 Part Found with A Large Score across the area with the 1.257" hole. | [Signature] | Scrap and Destroy no replace extras made. | [Signature] 9/11/24 | [Signature] 09/11/24 | [Signature] | [Signature] 09/11/23 |
| | | Re. water jet passed across with pressure. Machine modification | [Signature] | | | | [Signature] | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 53833

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Page 2

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

104

0.00

Small Fab

Memo

0.00

Small Fab

Form as per drwg
D4011 Rev.B

105

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

106

0.00

Packaging

Memo

0.00

Packaging

identify & stock Location_____

MF 09-11-24

Work Order ID 53833

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Page 3

Item ID: D4011-3

Accept



Setup Start



Revision ID:

Item Name: Clamp, Long

Stop



Start Date: 11/19/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/24/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

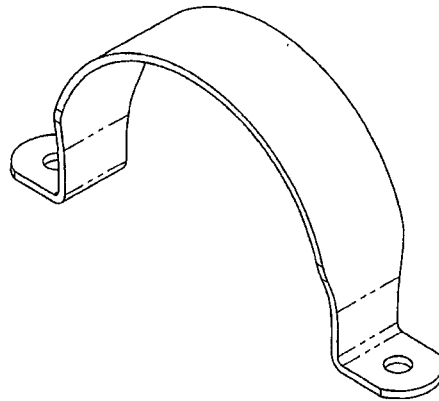
0.00

Quality Control

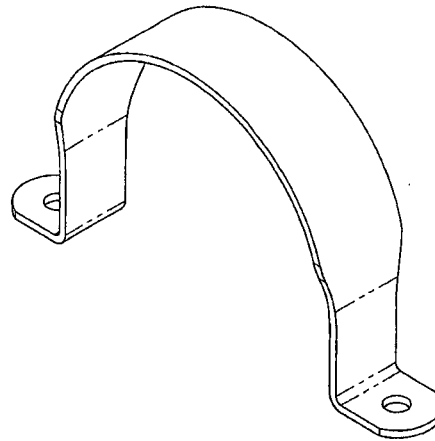
09/11/24

MF
09-11-24

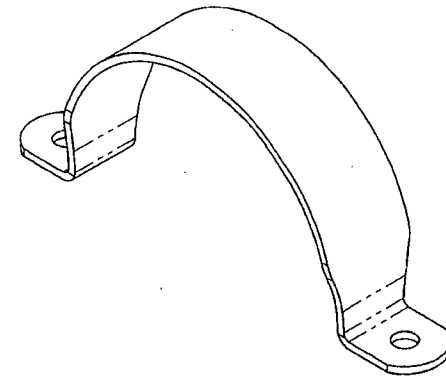
u10 53833



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



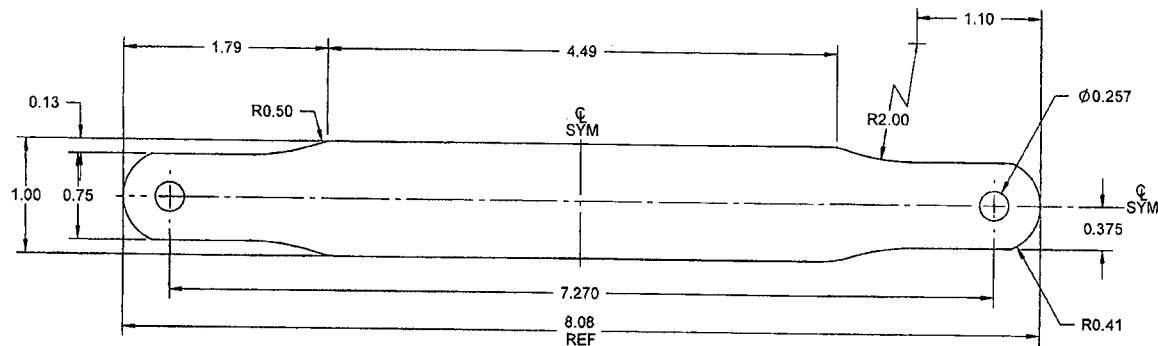
D4011-5 CLAMP, SHORT (OEM)

NOTES:

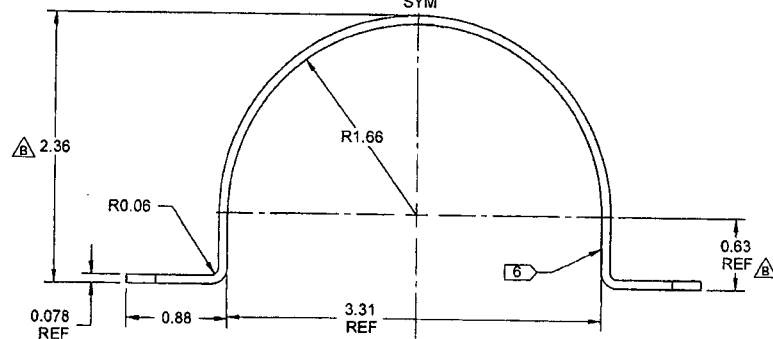
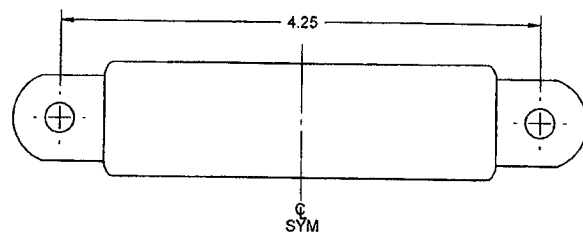
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

| | | | |
|------------|--|---|--------------|
| B | SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES | MB | 09.11.11 |
| A | NEW ISSUE | MB | 09.10.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. B |
| MFG. APPR. | NS | D4011 | SHEET 1 OF 4 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | SH | CLAMP | NTS |
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W/D 53833



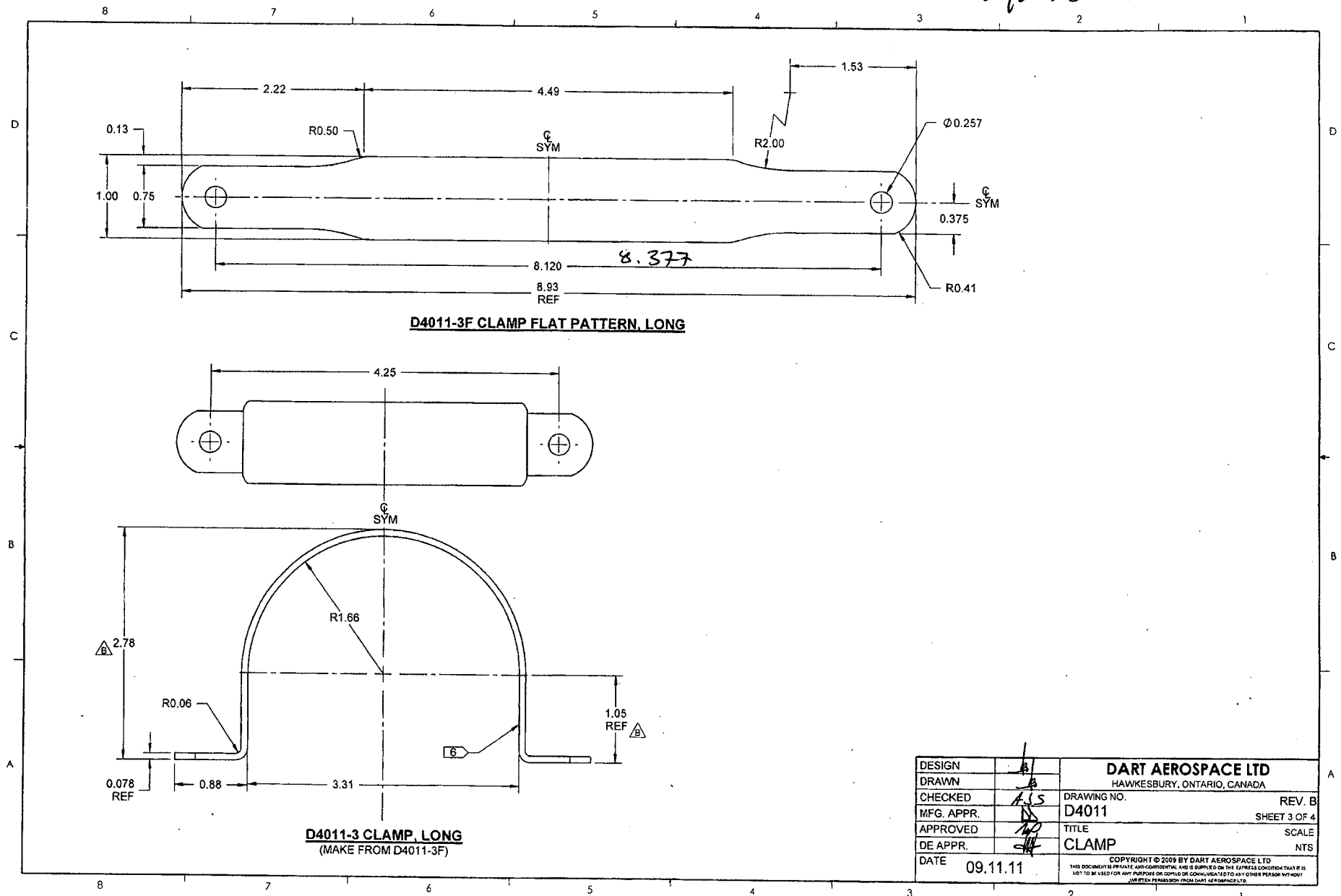
D4011-1F CLAMP, SHORT FLAT PATTERN



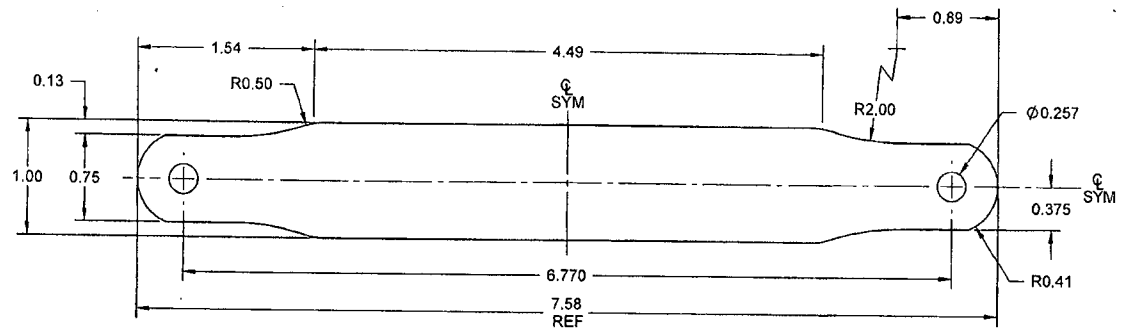
D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

| | | | |
|------------|----------|---|--------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4011 | REV. B |
| MFG. APPR. | | SHEET 2 OF 4 | |
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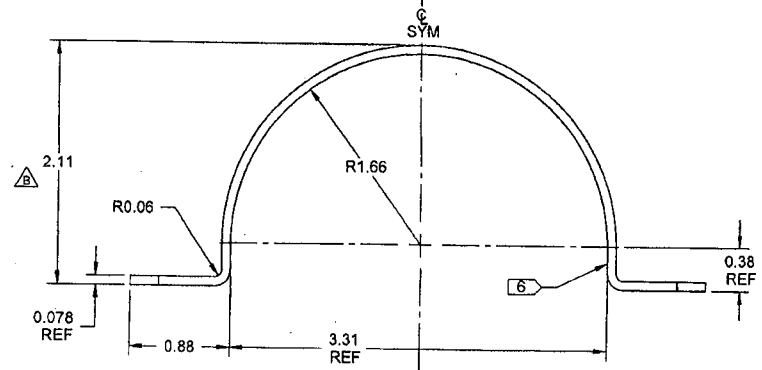
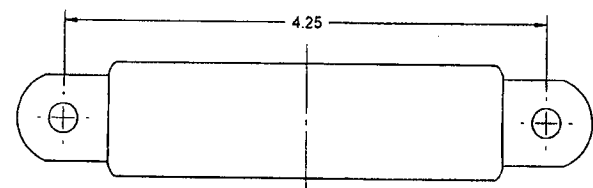
WU 53833



WU 53833

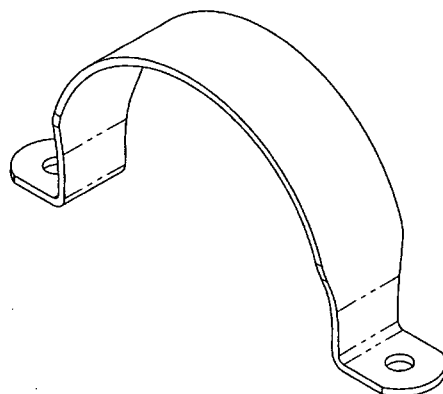


D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN

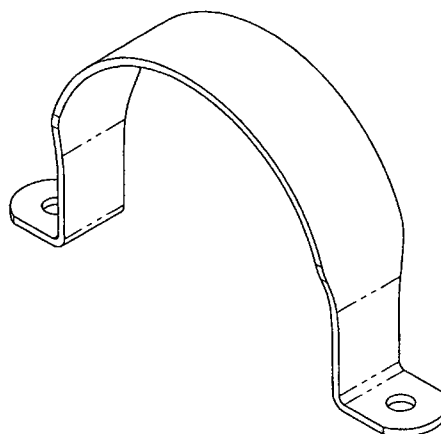


D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

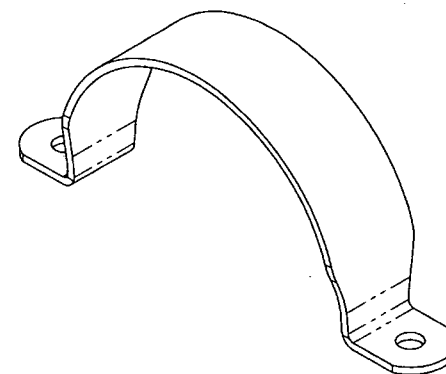
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| DRAWN | 1 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 1.5 | DRAWING NO. | REV. B |
| MFG. APPR. | 1 | D4011 | SHEET 4 OF 4 |
| APPROVED | 1 | TITLE | SCALE |
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D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

53833

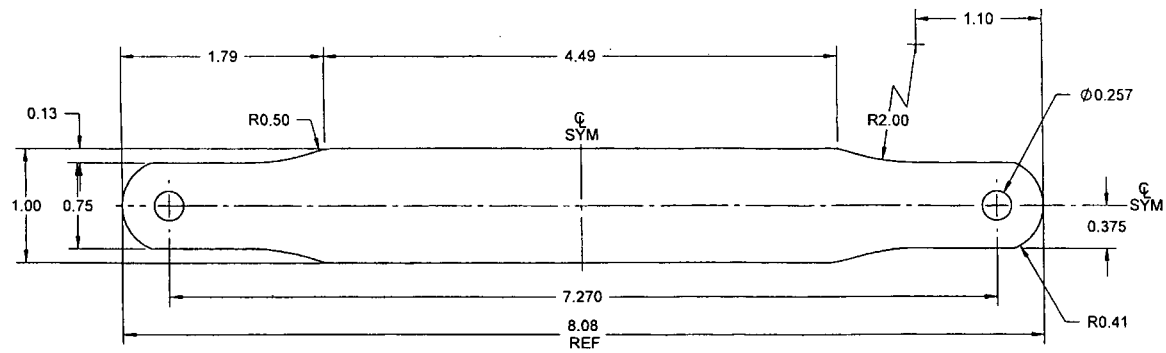
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2009-11-24

NOTES:

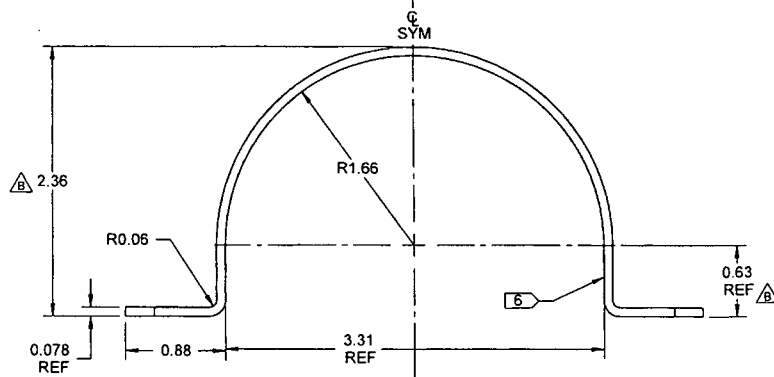
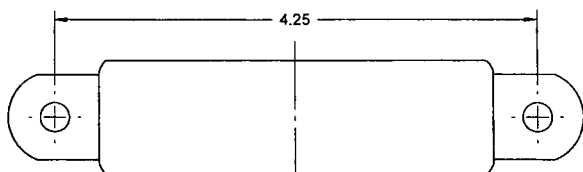
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PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
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- 7) WEIGHT: 0.02 lbs EACH

| | | | | |
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| A | NEW ISSUE | | MB | 09.10.21 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | DART AEROSPACE LTD | | | |
| DRAWN | HAWKESBURY, ONTARIO, CANADA | | | |
| CHECKED | ASS | DRAWING NO. | REV. B | |
| MFG. APPR. | ND | D4011 | SHEET 1 OF 4 | |
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| DE APPR. | ND | CLAMP | NTS | |
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8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

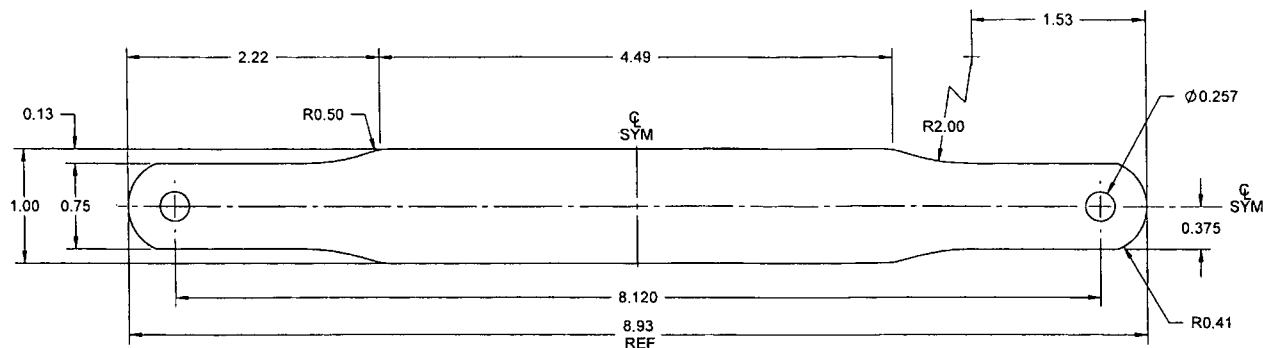
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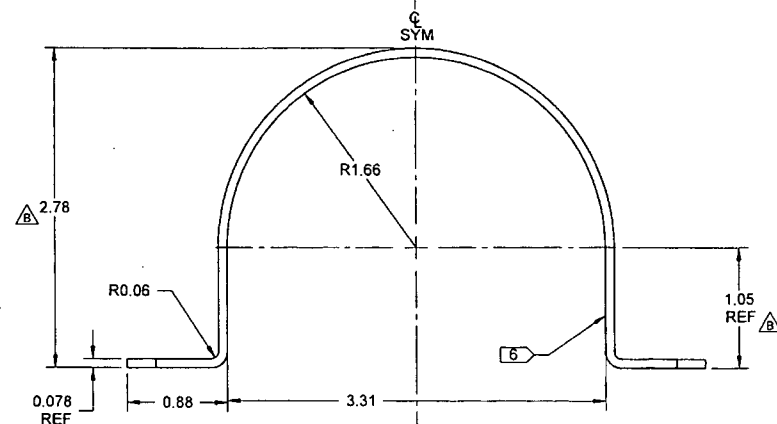
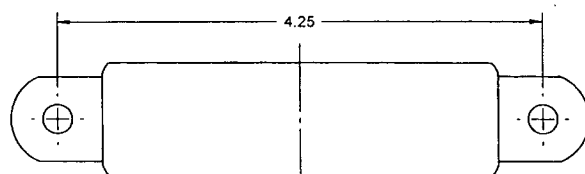
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | | D4011 | SHEET 2 OF 4 |
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG



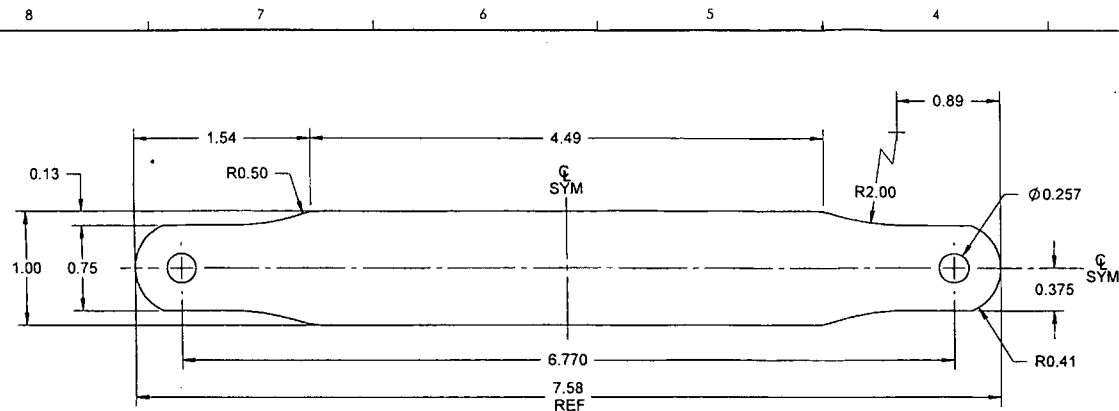
D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

53833

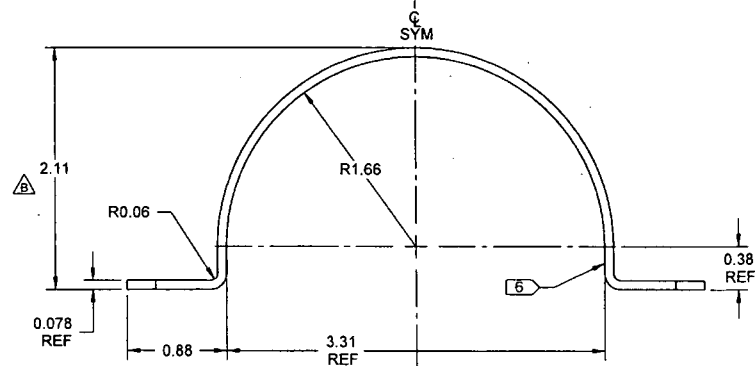
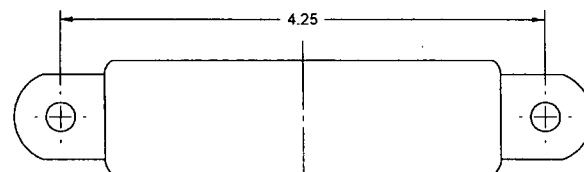
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2009-11-24
MP

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|------------|----------|--|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ALS | DRAWING NO. | REV. B |
| MFG. APPR. | | D4011 | SHEET 3 OF 4 |
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8 7 6 5 4 3 2 1



D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

| | | | |
|--|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | | D4011 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
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